

FIGURE 3: D3926-3 WEDGE INSTALLATION

47768

DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	ASS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9456	SHEET 3 OF 3
APPROVED	149	TITLE	SCALE
DE APPR.	149	WEDGE KIT	NTS
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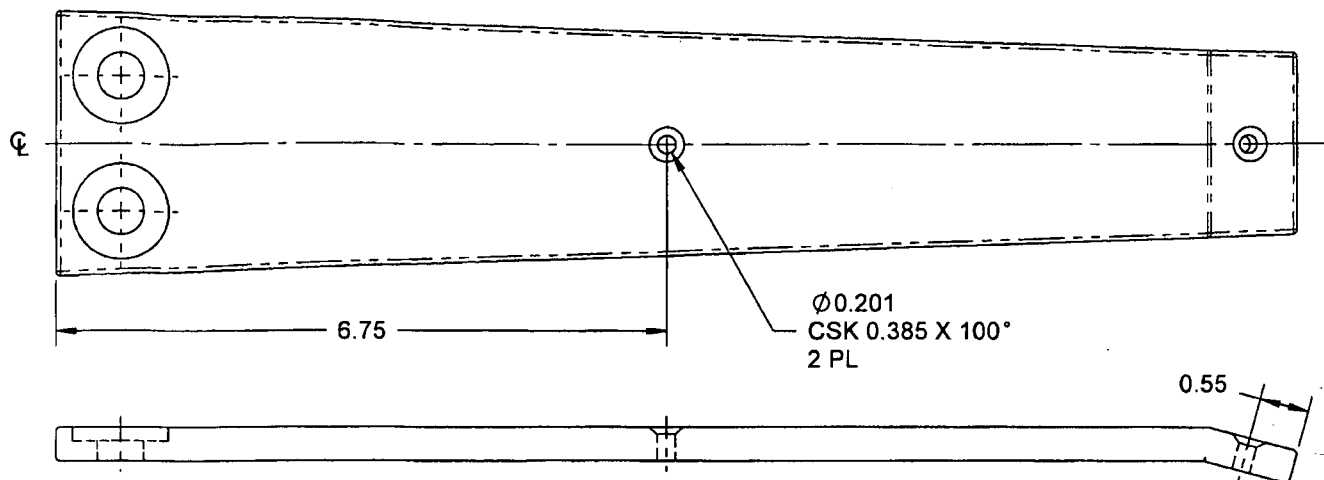


FIGURE 1: D2741 BLADE DRILLING DETAIL

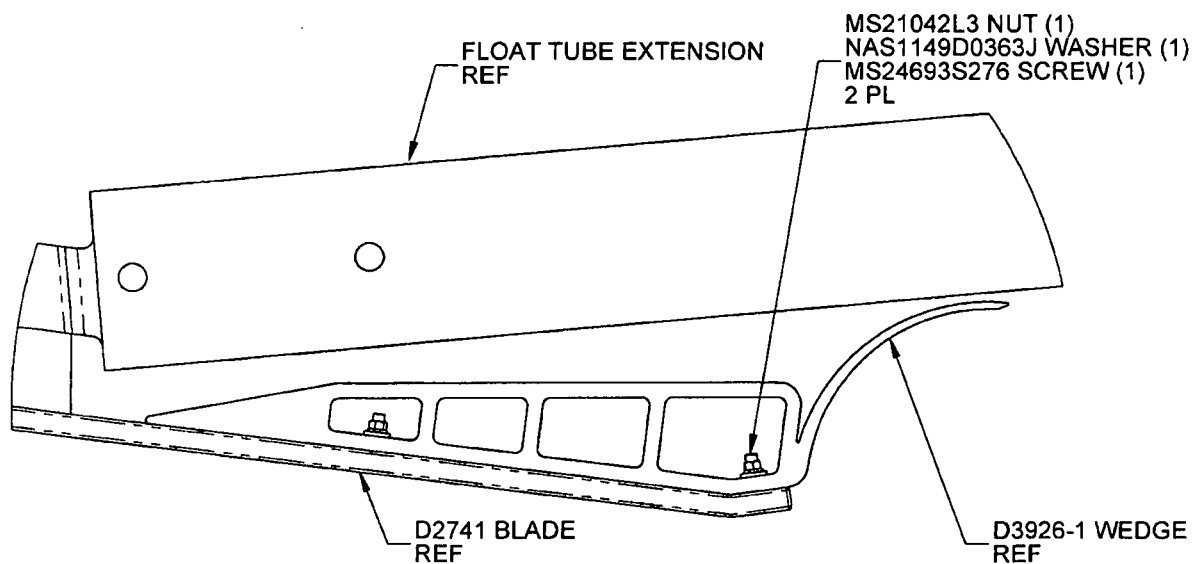


FIGURE 2: D3926-1 WEDGE INSTALLATION

47768

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MFG. APPR.	N/A	DSI 9456	SHEET 2 OF 3
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105A/B Wedge Kits can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105A Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA with the low angle float extensions but is not compatible with OEM skid tubes. The D350-636-105B Wedge Kit is compatible with non-float tube equipped skid tubes but is not compatible with OEM skid tubes.

The D350-636-105A/B Wedge kits are installed as follows:

- 1) Remove the D2741 blades from the D350-636 skidtube assemblies
- 2) Drill 2x $\varnothing 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\varnothing 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1/-3 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\varnothing 0.201$ (#7 drill) from each D2741 blade to the D3926-1/-3 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Install the D3926-3 wedge on each D2741 blade using the hardware shown in Figure 3 Sheet 3
- 9) Re-install the D2741 blade onto the D350-636 skidtube assembly in accordance with IIN-D350-636.
- 10) It is acceptable to install blade tape (abrasion strip material) on the float tube extension to prevent wear between the D3926-1 wedge and the float tube extension.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105A Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg
D350-636-105B Wedge Kit	0.50 lb 0.23 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	89.13 in-lb 1.04 m-kg

PARTS LIST

QTY. -105A	QTY. -105B	PART NUMBER	DESCRIPTION
X		D350-636-105A	Wedge Kit
	X	D350-636-105B	Wedge Kit
2		D3926-1	WEDGE
	2	D3926-3	WEDGE
4	4	MS21042L3	NUT
4	4	MS24693S276	SCREW
4	4	NAS1149D0363J	WASHER

47768

A	NEW ISSUE	09.07.23
REV.	DESCRIPTION	BY DATE
DESIGN	AS	DART AEROSPACE USA, INC. PORT HADLOCK, WA
DRAWN	AS	
CHECKED	AS	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9456 SHEET 1 OF 3
APPROVED	AS	TITLE SCALE
DE APPR.	AS	WEDGE KIT NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

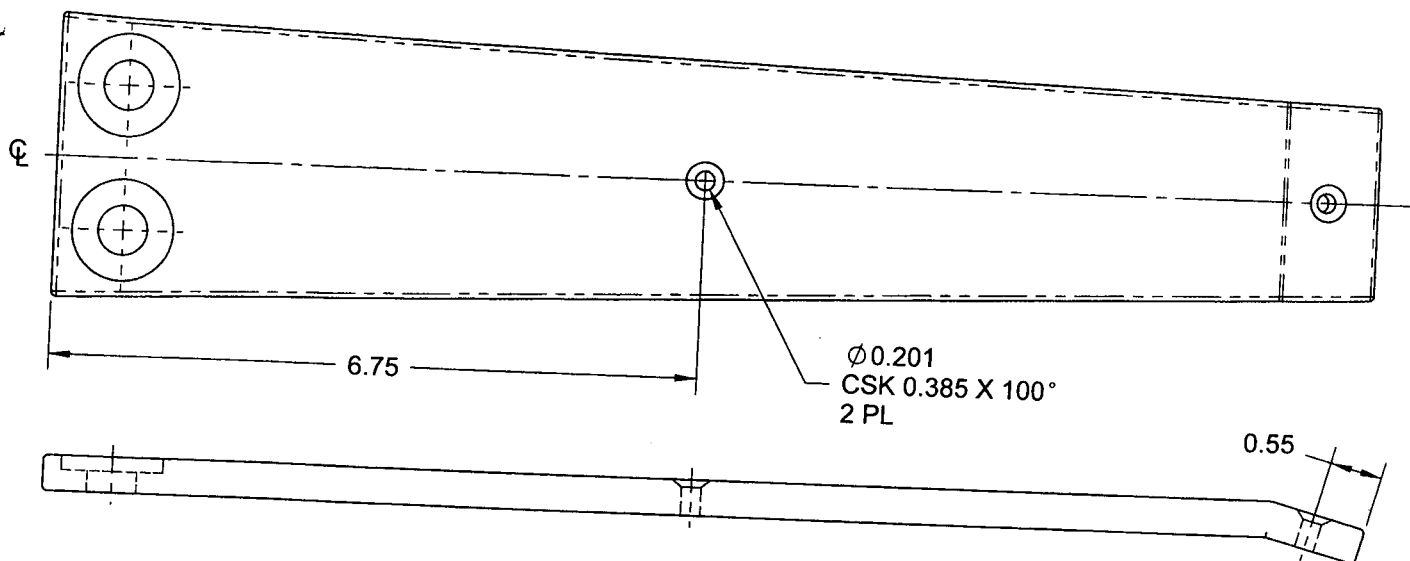


FIGURE 1: D2741 BLADE DRILLING DETAIL

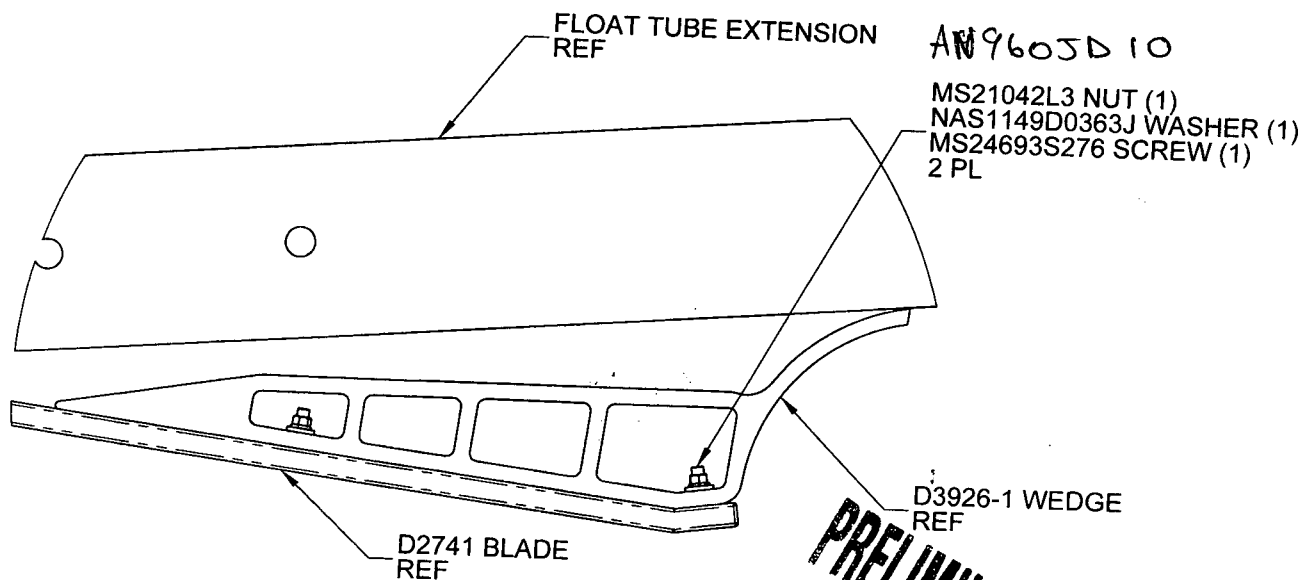


FIGURE 2: D3926-1 WEDGE INSTALLATION

PRELIMINARY ISSUE
MP 08/05/01

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MFG. APPR.	N/A	DSI 9456	SHEET 2 OF 2
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DE APPR.		WEDGE KIT	NTS
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-636 REV. F OR EARLIER

REF. FAA STC: SR00646SE

REF. TCCA STC: SH99-7

REF. CAA AIRWORTHINESS APPROVAL NOTE: 28081, 28082

The D350-636-105 Wedge Kit can be installed on D350-636-011/-012/-013/-014 Skidtube installations to help prevent the D2741 blade from getting snagged on objects on the ground during take-off. The D350-636-105 Wedge Kit is compatible with Apical Float Systems per STC SR00470LA, SR00645LA and SR00831LA but is not compatible with OEM skid tubes.

The D350-636-105 Wedge kit is installed as follows:

- 1) Remove the D2741 blades from the D350-636 skid tube assemblies
- 2) Drill 2x $\phi 0.201$ (#7 drill) per D2741 blade as shown in Figure 1 Sheet 2 and deburr
- 3) Countersink the 2 holes $\phi 0.385 \times 100^\circ$ from the bottom of each D2741 blade
- 4) Position the D3926-1 wedge on the top side of each D2741 blade centered between the left and right sides
- 5) Transfer drill 2x $\phi 0.201$ (#7 drill) from each D2741 blade to the D3926-1 wedge and deburr
- 6) Touch up holes in D2741 blade with primer per Aircraft Maintenance Manual
- 7) Install the D3926-1 wedge on each D2741 blade using the hardware shown in Figure 2 Sheet 2
- 8) Re-install the D2741 blade unto the D350-636 skid tube assembly in accordance with IIN-D350-636.

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-636-105 Elf Shoe Kit	0.06 lb 0.03 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.25 in 4.53 m	10.70 in-lb 0.14 m-kg

PARTS LIST

QTY. -105	PART NUMBER	DESCRIPTION
X	D350-636-105	Wedge Kit
2	D3926-1	WEDGE
4	MS21042L3	NUT
4	MS24693S276	SCREW
4	NAS1149D0363J	WASHER

PRELIMINARY ISSUE
WP 09/05/01

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MFG. APPR.	N/A		
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DE APPR.			
DATE	09.03.31		
DART AEROSPACE USA, INC. PORT HADLOCK, WA		REV. SHEET 1 OF	
DRAWING NO. DSI 9456		SCAL NT	
TITLE WEDGE KIT			
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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 10:28:20 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: DSI 9456

Job Number: 47768

Part Number: REWORK20

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ID UNDER ORIGINAL D350-636-105 B47754
GIVE TO MIKE P

SEE NOTE BELOW

09/09/01

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL
EFFECTIVE 9-5-7 AUTH h
RELEASED MP DATE 09/06/04
* PARTS SENT TO ERA.
WITH COFC ONLY. SENT
WITH ~~PRELIM~~ PRELIM DSI.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 10:28:20 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: DSI 9456
Job Number	: 47768		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: REWORK20
This Issue	: 07/05/2009 S.O. No. :	Drawing Number	: WEDGE INSTALLATION
Prsht Rev.	: NC	Project Number	:
First Issue	: 07/05/2009 Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 13/05/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>ME 09-05-01</u>		
Comment	:		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2741	Blade, 350 Skidtube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Blade, 350 Skidtube

2.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

PULL FROM STK 2 X D2741 B 45230
 DRILL 2 HOLES AND COUNTERSINK PER DRAWING D2741 (DSI 9456)

and 09/05/11 (2)
WHITE IMRON
MP 09/05/12

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0	D350636105	Wedge Installation
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Wedge Installation

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

ASSEMBLE X 2 D2741 ON D350-636-105 PER DSI 9456

090514 1
090514 1
090608

5.1 Hardware M521042 L3 NUT M110844
 M524693-5276 SCREW M104374
 AN960 JB 10 washer M11279

QTY 2
 QTY 2
 QTY 2